

**Work Order ID 102098****\*102098\***

Ship Wedn.

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Friday, May 24, 2013 11:30:15 AM

Item ID: D3121-241

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Bearing Assembly

Start Date: 5/24/2013 Start Qty: 60.00

**\*60\***

Cust Item ID:

Required Date: 5/29/2013 Req'd Qty: 60.00

**\*60\***

Customer:

Reference:

Approvals:

Process Plan: *muf*Date: *BS-24*

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3121

Rev E

130

0.00

**\*130\***

Small Fab

Small Fab

Memo

0.00

Small Fab

1-Press D3121-23 Bearing into D3121-25 Cap as per Dwg D3121

140

0.00

**\*140\***

QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

150

0.00

**\*150\***

Packaging

Identify as per dwg & Stock Location: *8-23*

Memo

0.00

Packaging

*60x* *BS-27**60*  
*all**60x* *BS-27*

**Work Order ID 102098**

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Item ID: D3121-241      Accept      **\*N900040100\***      Setup Start **\*NS1\***  
Revision ID:      Stop **\*NS2\***  
Item Name: Bearing Assembly  
Start Date: 5/24/2013      Start Qty: 60.00      **\*60\***      Cust Item ID:  
Required Date: 5/29/2013      Req'd Qty: 60.00      **\*60\***      Customer:  
Reference:

Approvals:      Process Plan:      Date:      Tooling:      Date:      Run Start **\*NR1\***  
QC:      Date:      SPC (Y/N):      Date:      Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									

\_\_\_\_\_ MLJ 13-05-27 \_\_\_\_\_

*MF*  
*135-27*

# Picklist Print

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Work Order ID: 102098  
 Parent Item: D3121-241  
 Parent Item Name: Bearing Assembly

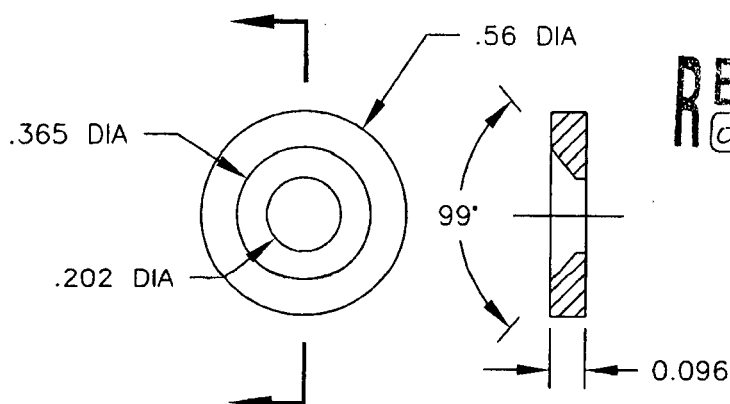
Start Date: 5/24/2013 Required Date: 5/29/2013  
 Start Qty: 60.00 Required Qty: 60.00

Comments: IPP Rev:A04.02.18New issueKJ/DS  
 IPP Rev:B ECN 1060 07-11-12 DD verified by:EC

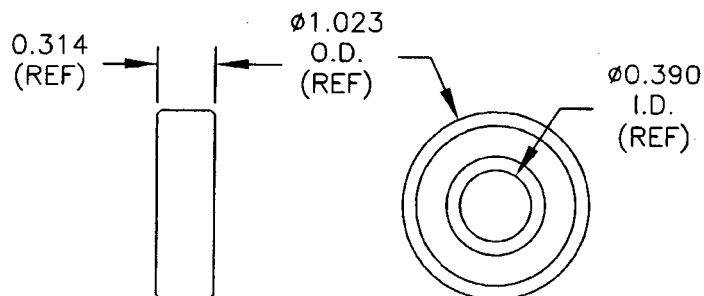
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3121-25 Cap		Manufactured	No				Each	92.0000		60		5/23/05/27	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST235		92							
				91747		42				42			
				97905		50				18			
D3121-23 Bearing		Manufactured	No			130	Each	76.0000	1	60		5/23/05/27	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST235		76							
				66734		10							
				75084		2							
				99000		64				60			

**DART**

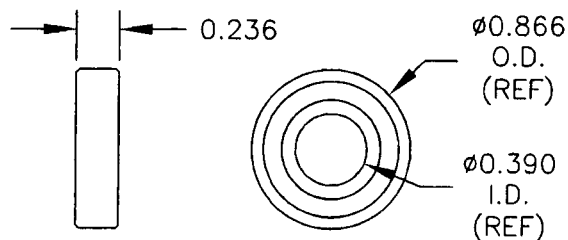
DESIGN #	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 10 OF 10
DATE 07.11.07	TITLE BRACKET ASSEMBLY		SCALE 1:1

**D3121-17 WASHER (SCALE 2:1)**

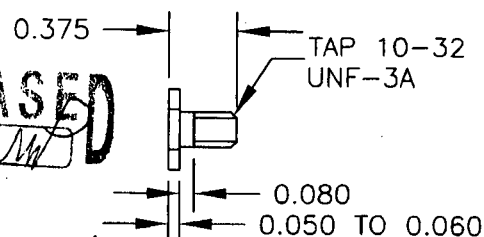
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

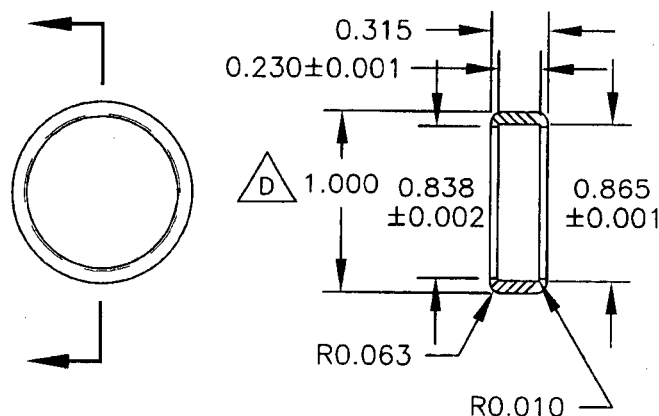
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

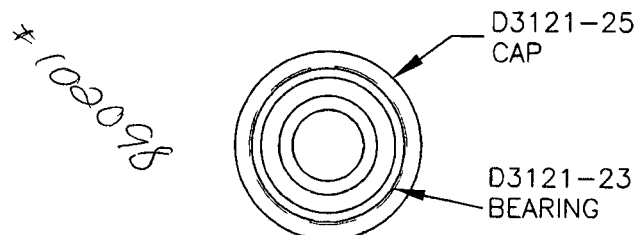
- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-2Z
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD,  $\phi$ 1.25 (REF DART SPEC. M-DELIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**

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